

shy April 24

# Work Order ID 82769

\*82769\*

Page 1

April-09-12 10:12:00 AM

Item ID: D4092-042

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Maintenance Step Assembly

Start Date: 4/09/12 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 4/19/12 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4092

B

100

Pick Kit

0.00

\*100\*

Packaging

Memo

0.00

Packaging

12

Ø

*EB*  
*12/04/25*

110

0.00

\*110\*

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg  
Torque screws up to 15-25 in- lbs

12

Ø

*EB*  
*12/04/25*

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

*Schultz*

*72*

*RM*

# Work Order ID 82769

**\*82769\***

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April-09-12 10:12:00 AM

Item ID: D4092-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Maintenance Step Assembly

Start Date: 4/09/12 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 4/19/12 Req'd Qty: 12.00 **\*12\*** Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>57270</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	PNP 82763 10X 2 Stone 5T								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*Copy 2 5/12*

*12/4/25*

*MF 5/20/12*

# Picklist Print

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Page 1

Work Order ID: 82769

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 4/09/12

Required Date: 4/19/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD  
639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 Maintenance Step		Manufactured	No				Each	4.0000		24		4/12/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		3							
				77852		1							
				80564		2							
				ST241A		1							
				74303		1							
D4093-1 Bracket		Manufactured	No				Each	7.0000		12		4/12/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST195		7							
				78911		7							
D4093-3 Bracket		Manufactured	No				Each	21.0000		12		4/12/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST195		21							
				77850		1							
				80084		20							
D4093-5 Bracket		Manufactured	No				Each	14.0000		24		4/12/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST124		14							
				80085		2							
				80226		12							

B82765  
(24)

B82766  
(12)

B83639  
(5)

B82764  
(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82769

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 4/09/12

Required Date: 4/19/12

Start Qty: 12.00


Required Qty: 12.00

MS24694-S54 Purchased No Each 124.0000  
Screw

Location	Loc Qty	Loc Code
ST289A	124	
120142	4	
120361	20	
121166	100	

MS24694-S55 Purchased No Each 183.0000  
Screw

Location	Loc Qty	Loc Code
ST289A	183	
119307	33	
120833	50	
120910	100	

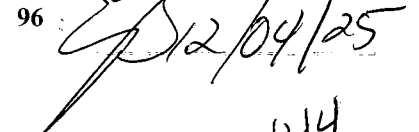
 MS24694-S56 Purchased No Each 59.0000  
SCREW

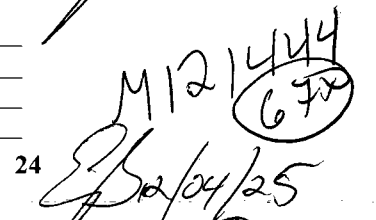
Location	Loc Qty	Loc Code
ST289A	59	
120142	34	
120833	25	

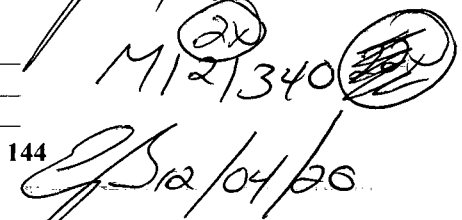
NAS1149D0332J Purchased No Each 3,309.0000  
Washer

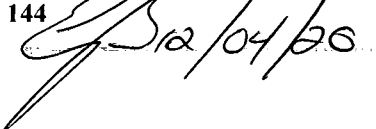
Location	Loc Qty	Loc Code
ST298	3309	
105793	12	
110985	4	
117087	89	
119042	38	
119717	620	
120644	546	
121011	2000	

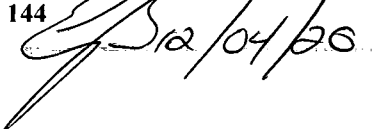
24  12/04/20

96  12/04/25

29  12/04/25

24  12/04/25

22  12/04/20

144  12/04/20

144  12/04/20

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Shop Packet Print

Page 2

# Picklist Print

April-09-12 10:12:00 AM

Page 3

Work Order ID: 82769

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 4/09/12

Required Date: 4/19/12

Start Qty: 12.00

Required Qty: 12.00

MS21042L3

Purchased

No

Each

2,274.0000

144

Nut

*EP 2/04/25*

Location

Loc Qty

Loc Code

ST300

2274

117441

16

117885

32

118451

5

118927

3

119017 —

2030

119075

166

121162

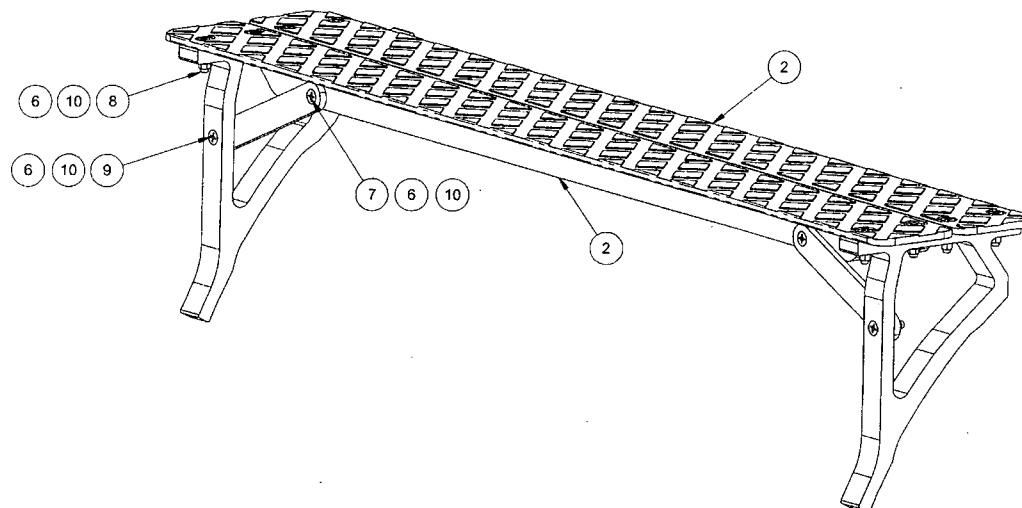
22

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
*144*  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

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Shop Packet Print

Page 3



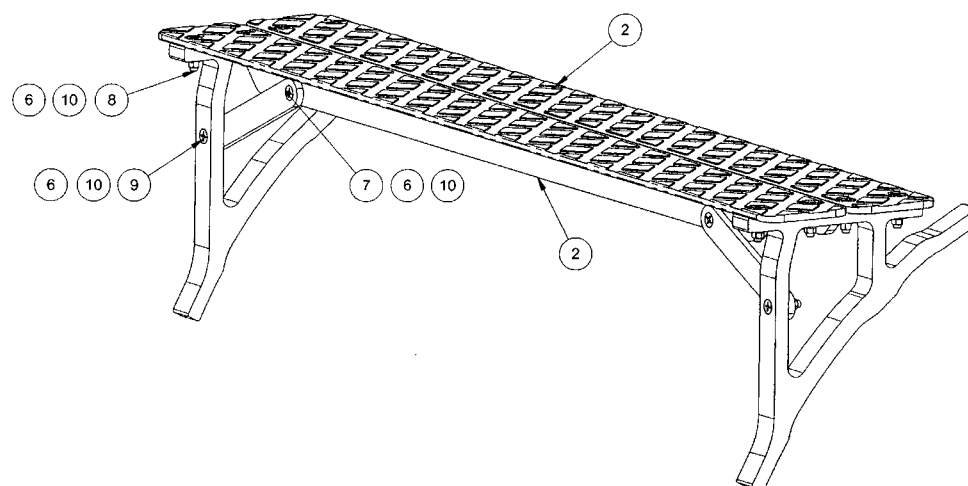
**D4092-041 MAINTENANCE STEP ASSEMBLY**

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

**RELEASED**  
2011-09-22

B	REDRAWN, LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 1 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
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ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



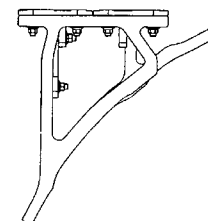
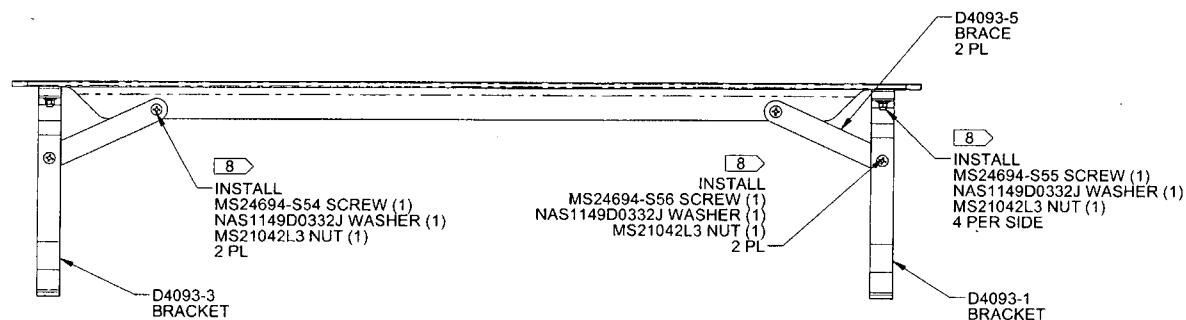
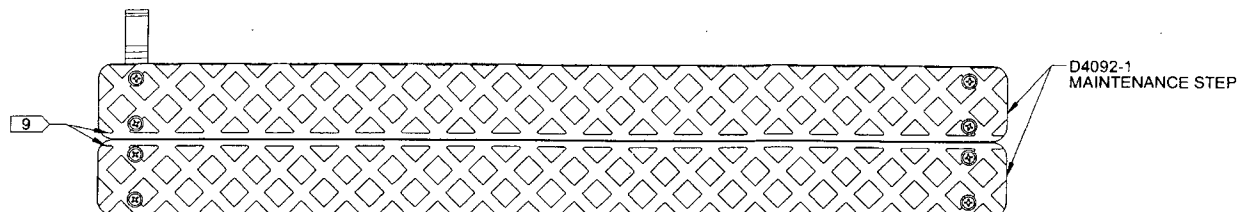
**D4092-042 MAINTENANCE STEP ASSEMBLY**



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MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASSY	NTS
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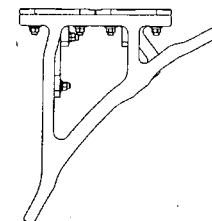
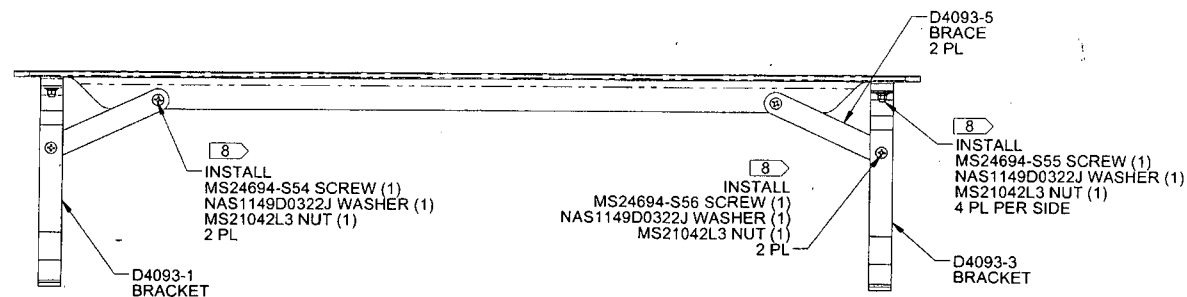
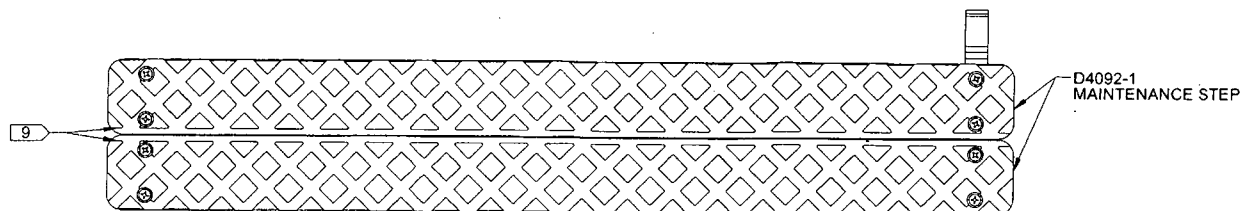
# **D4092-041 MAINTENANCE STEP ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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2011-09-22

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CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	<b>D4092</b>	SHEET 3 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	<b>MAINTENANCE STEP ASS'Y</b>	NTS
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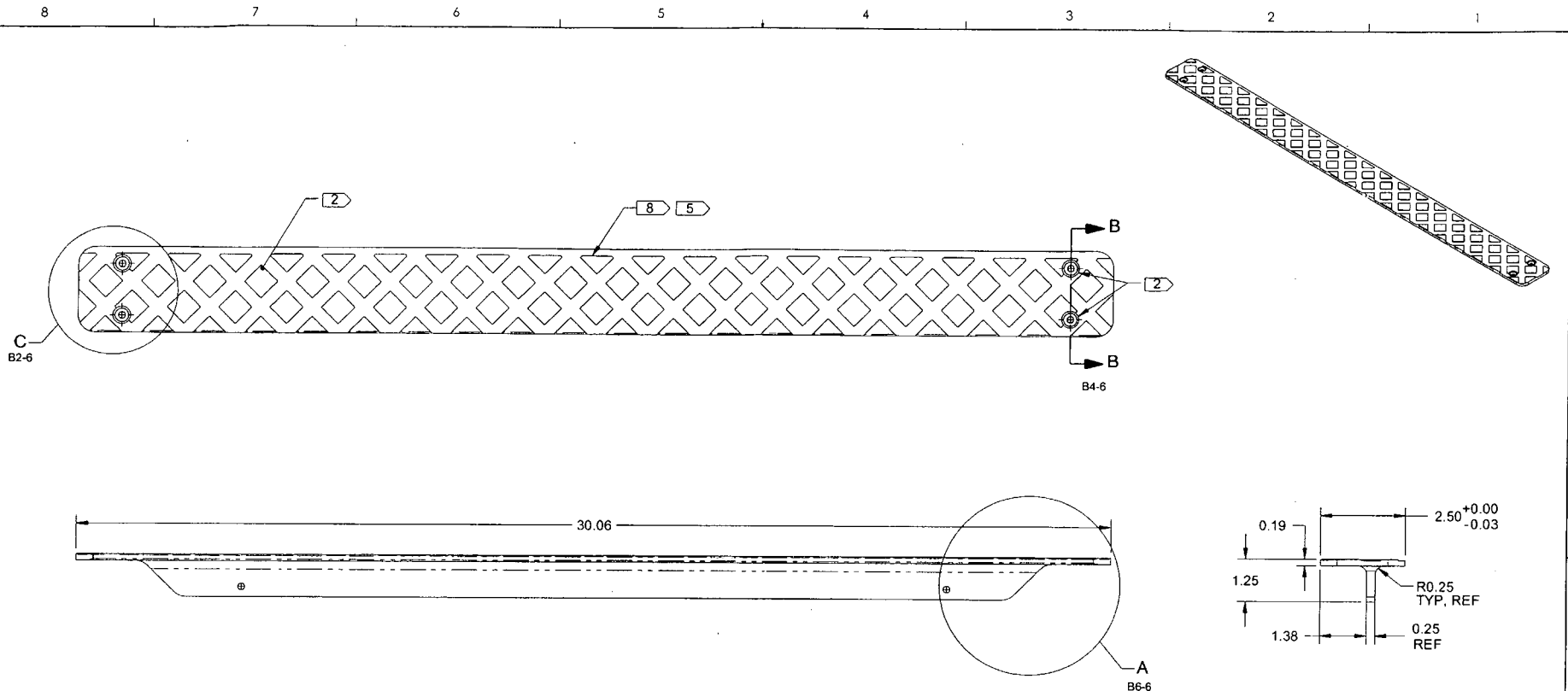
### D4092-042 MAINTENANCE STEP ASSEMBLY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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2011-09-22

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CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 4 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
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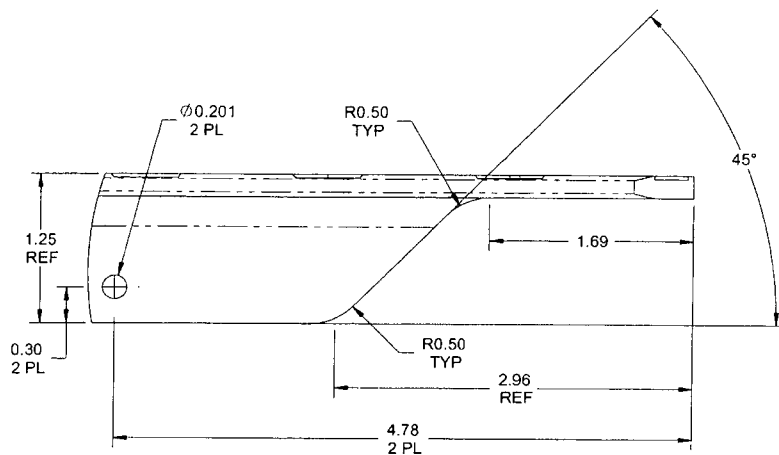
**D4092-1 MAINTENANCE STEP**  
(MAKE FROM D2761 EXTRUSION)

**RELEASED**  
2011-09-22  
JW

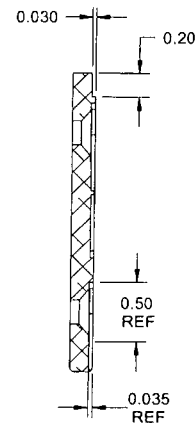
**NOTES:**

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4  
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

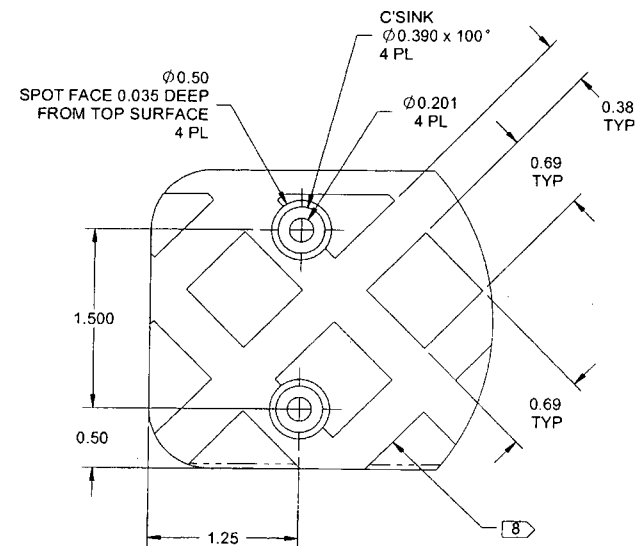
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	<b>D4092</b>	SHEET 5 OF 6
APPROVED	140	TITLE	SCALE
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**DETAIL A** B3-5  
SCALE 3X, TYP



**SECTION B-B** C3-5  
SCALE 3X, TYP



**DETAIL C** C8-5  
SCALE 3X, TYP

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2011-09-22  
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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4092</b>	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MAINTENANCE STEP ASS'Y</b>	NTS
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